

Date: Wednesday, 29/10/2008 10:13:49 AM  
 User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD BLADE FOLD ASSY WELDMENT
Job Number	: 43063		
Estimate Number	: 13418		
P.O. Number	:	Part Number	: PB674300107
This Issue	: 29/10/2008 S.O. No. :	Drawing Number	: B6743001 P.5
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 42753	Material	:
Written By	:	Due Date	: 05/11/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>MF 08-10-30</u>		
Comment	: Est Rev:A 08-06-25 new issue DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300147	Base Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Base Assembly  
 batch:- 343055V

*Pl 08-11-27*

2.0	PB6743001205	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Outer Tube  
 batch:- 41485V

*Pat E Pl 08-11-27*

3.0	PB6743001197	Outer Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Outer Tube  
 batch:- 341483V

*Pat E Pl 08-11-27*

4.0	PB6743001211	Square Tubing
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Square Tubing  
 batch:- 41487

*mf 08-11-04*

5.0	PB6743001209	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Square Tubing  
 batch:- 43073V

*Pl 08-11-27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/10/2008 10:13:49 AM  
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Part Number: PB674300107

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PB6743001201	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Square Tubing  
batch:- 41572

mf 08-11-04

7.0	PB6743001203	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Square Tube  
batch:- 41789

mf 08-11-04

8.0	PB6743001207	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Square Tube  
batch:- B43199 ✓

Pl 08-11-27

9.0	PB6743001219	Angled Male Eye
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Angled Male Eye  
batch:- B40041

mf 08-11-04

10.0	D34405	Contoured Detent Clip Base (Supersedes B
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Contoured Detent Clip Base  
batch:- 41203

mf 08-11-04

11.0	D34407	Detent Clip Base (Supersedes B67-43001-2
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Detent Clip Base  
batch:- 41204

mf 08-11-04

12.0	D344015	Contoured Male Eye (Supersedes B67-43001
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Contoured Male Eye  
batch:- B41202

mf 08-11-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number: 43063

Part Number: PB674300107

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



①

Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8813 and weld as per dwg PB67-43001

\*\*\* ensure no burn thru after welding in tube -205 and -197 only where bushing -265 \*\*\*

08/11/27

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/11/28 ①

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/11/29 ①

16.0

POWDER COATING

POWDER COATING



①

Comment: POWDER COATING

\*\*\*mask inside of D3440-5, D3440-7 and D3440-15 prior to paint\*\*\*\*

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:30  
320 OF  
9:00

M-L 08/12/01

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 08/12/02 ①

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Finishing

FX 08/12/02 ①

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/03

Job Completion



MF 08-12-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

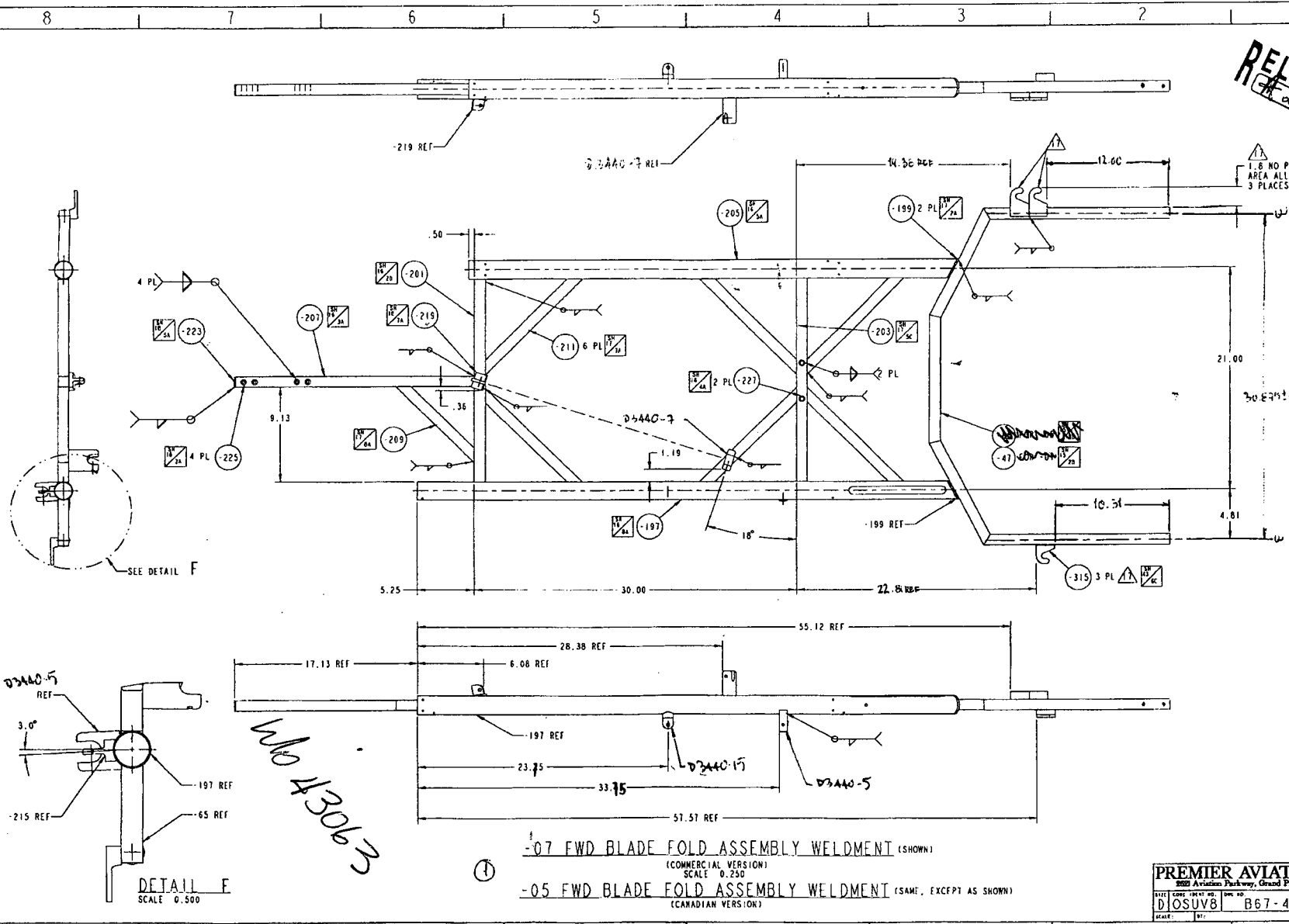
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**RELEASED**  
 06.01.20

1.8 NO PAINT THIS  
 AREA ALL AROUND -315  
 3 PLACES



-07 FWD BLADE FOLD ASSEMBLY WELDMENT (SHOWN)  
 (COMMERCIAL VERSION)  
 SCALE 0.250  
 -05 FWD BLADE FOLD ASSEMBLY WELDMENT (SAME, EXCEPT AS SHOWN)  
 (CANADIAN VERSION)

**PREMIER AVIATION, INC.**  
 3800 Aviation Parkway, Grand Prairie, Texas 75050  
 DATE: 08-19-84 BY: [signature] DWG NO: D105UV81  
 SCALE: 1/2"=1'-0" SHEET: 5 OF 45

**ORIGINAL**